

Work Order ID 78269

\*78269\*

Page 1

January-04-12 11:17:22 AM

Item ID: D350-636-012

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube RH

Start Date: 04/01/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/04

Tooling:

Date:

Run Start \*NR1\*

QC: Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

\*100\*

DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

81261/73

MLJ 12-1-23  
①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78269****\*78269\***

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January-04-12 11:17:22 AM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 04/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	*Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							
<b>*110*</b>	Skidtubes								
Skidtubes		0.00							
Skidtubes	<p><b>Memo</b></p> <p>1- Pick D2600-3 Bent</p> <p>2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750</p> <p>3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.</p> <p>4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting</p> <p>5- Drill only two fwd step holes using DT9616. Ensure proper positioning.</p> <p>6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details).Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)</p> <p>7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***</p> <p>8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail L to 0.500" (8 holes per side)</p> <p>9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".</p> <p>10-Open up holes of Detail A to 0.297" (total of 2 holes per side)</p>								

JW

12-1-6

B 12/01/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 78269****\*78269\***

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January-04-12 11:17:22 AM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 04/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: M11971286 12-01-09

12-Grind welds flush as per Dwg D2750

3B 12/01/09

120

QC10- Inspect visual per QSI004- ground welds

0.00

**\*120\***

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 78269

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January-04-12 11:17:22 AM

Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 04/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 18/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
<b>*160*</b>									
Skidtubes									
Skidtubes	<p><b>Memo</b></p> <p>1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.</p> <p>2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.</p> <p>3-Open float holes to .500" (4 per Side)</p> <p>4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)</p> <p>5-Deburr and blow out all chips from inside of tube</p> <p>6-Prepare tube for welding, remove alodine as required.</p> <p>7-Bond web D2739 in place as per QSI 015  A/R Sikaflex-291 batch: <u>M119503</u>  exp. date: <u>12-01-13</u></p> <p>8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)  A/R Aluminum Rod batch: <u>M119712</u></p> <p>9- At section AP-AP drill out x-bolt spacer to 0.404"</p> <p>10-Grind welds flush as per Dwg D2750</p> <p>11-Spot face ground handling holes section (total of 4 places per side) as per</p>	0.00							

BE 12-01-09

SAP 12-01-09

BE 12-01-10

BE 12-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78269****\*78269\***

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January-04-12 11:17:23 AM

Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube RH

Start Date: 04/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***


QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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dwg D2750

12-Deburr holes

 12/01/11

170

QC10- Inspect visual per QSI004- ground welds

0.00

**\*170\***

QC

Memo

0.00

Quality Control

S 12/01/11

180

QC5- Inspect part completeness to step on W/O

0.00

**\*180\***

QC

Memo

0.00

Quality Control

S 12/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 78269

**\*78269\***

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January-04-12 11:17:23 AM

Item ID: D350-636-012 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube RH  
 Start Date: 04/01/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 18/01/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190	Pressure Wash per QSI005 4.3	0.00							
<b>*190*</b>									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								

① CF 12-1-12

200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*200*</b>									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:50 OVEN TEMPERATURE: 320°F FINISH TIME: 4:20								

1X ym 12/04/17

210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

1 BL 12-1-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 78269****\*78269\***

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Item ID: D350-636-012

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 04/01/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
<b>*230*</b>									
HandFinish	Memo	0.00							
Hand Finishing	1-Install inserts as per dwg D2750								
	2-Inspect for Foreign Objects								
	3-Spray inside/of tube with "LPS-3" batch: <u>N/A.</u>								
	4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>119508</u> EXP DATE: <u>12-8</u>								
	5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>110548</u>								
	6-Coat all exposed fasteners with "LPS Procyon" batch: <u>114306</u>								

1 BR 12-1-20.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**\*78269\***

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**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

**Start Date:** 04/01/2012    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 18/01/2012      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

240	QC5- Inspect part completeness to step on W/O	0.00
-----	-----------------------------------------------	------

**\*240\***

## Memo

0.00 0 1210123

250	Pick Kit	0.00
-----	----------	------

**\*250\***

## Packaging

## Memo

0.00

### Packaging

260	QC4- 100% Inspect kits for completeness	0.00
-----	-----------------------------------------	------

**\*260\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Work Order ID 78269

**\*78269\***

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January-04-12 11:17:23 AM

Item ID: D350-636-012

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube RH

Stop **\*NS2\***

Start Date: 04/01/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 18/01/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
<b>*270*</b>	Packaging	0.00							
Packaging	Memo								
Packaging	Package as per PPP D350-636-012								
280		0.00							
<b>*280*</b>	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo								
Quality Control									

10/1/24 SP

12/1/25

12-01-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-04-12 11:17:26 AM

Page 1

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I02.09.25Rearranged procedure stepsKJ  
 IPP Rev:J 06-03-29 As per Rev D EC  
 IPP Rev:K 06-07-13 As per dsi9343 EC  
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC  
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC  
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O  
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as  
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-3-BENT

Manufactured No

110

Each

24.0000

1

1

**\*D2600-3-BENT\***

**\*\***

Extrusion Bent

Location

Loc Qty

Loc Code

LG

24

66875

7

73253

1

75021

1

75022

1

75023

1

77623

13

D2744

Manufactured No

110

Each

34.0000

1

1

**\*D2744\***

**\*\***

Cap

Location

Loc Qty

Loc Code

LG002

34

62715

1

70881

12

71861

21

JW 12-1-6

BE 12-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

January-04-12 11:17:26 AM

Page 2

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

3.0000

1

1

**\*D2739\***

350 I Beam

\*\*

SAD

12-01-09

Location

Loc Qty

Loc Code

LG

3

72155

1

76987

2

377621

169.0000

8

1

D2743

Manufactured No

160

Each

**\*D2743\***

Crossbolt Spacer

\*\*

BE12-0170

Location

Loc Qty

Loc Code

LG001

169

67766

4

68251

3

73403

64

74445

92

76141

6

8

D3490-3

Manufactured No

160

Each

62.0000

4

4

**\*D3490-3\***

Cross Bolt Spacer

\*\*

BE12-0170

Location

Loc Qty

Loc Code

LG001

62

74877

22

77567

40

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January-04-12 11:17:27 AM

Work Order ID: 78269

\*78269\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

70.0000

4

4

\*D3490-1\*

Cross Bolt Spacer

\*\*

BL 12-01-10

Location

Loc Qty

Loc Code

LG001

70

62450

2

67773

4

74875

24

77042

40

4

D3631-1

Manufactured No

230

Each

343.0000

8

8

\*D3631-1\*

Washer

\*\*

BL 12-1-20.

Location

Loc Qty

Loc Code

ST072

343

68062

2

75548 ✓

341

8

D3791-1

Manufactured No

230

Each

20.0000

1

1

\*D3791-1\*

Wearplate

\*\*

BL 12-1-20.

Location

Loc Qty

Loc Code

FP002

20

62239

2

74598

2

75041 ✓

16

1

D3793-3

Manufactured No

230

Each

13.0000

1

1

\*D3793-3\*

Wearshoe

\*\*

BL 12-1-20.

Location

Loc Qty

Loc Code

FP001

13

74528

1

75043 ✓

12

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

MS21043-6

Purchased

No

230

Each

373.0000

4

4

**\*MS21043-6\***

NUT

\*\*

*BL 12-1-20.*

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

353

112314 ✓

143

117887

10

118384

200

*4.*

D3794-1

Manufactured

No

230

Each

30.0000

1

1

**\*D3794-1\***

Gasket

\*\*

*BL 12-1-20.*

Location

Loc Qty

Loc Code

FP002

30

74594

2

75042 ✓

28

*1*

NAS1611-010

Purchased

No

230

Each

79.0000

8

8

**\*NAS1611-010\***

O-RING

\*\*

*BL 12-1-20.*

Location

Loc Qty

Loc Code

FP001

79

110915

14

117460

8

118077

1

118612

3

119438

47

119623

6

*8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-04-12 11:17:27 AM

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250

Each

17.0000

1

1

\*\*

**\*D2741\***

Blade, 350 Skidtube

Location

Loc Qty

Loc Code

ST

-10

ST466

27

71856

17

71856

NAS1515H3L

Purchased

No

230

Each

179.0000

4

4

\*\*

**\*NAS1515H3I \***

WASHER

BL 12-1-20.

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

139

118686

3

119438

36

120072

100

4.

NAS1611-013

Purchased

No

230

Each

96.0000

8

8

\*\*

**\*NAS1611-013\***

O-RING

BL 12-1-20.

Location

Loc Qty

Loc Code

FP001

96

116582

5

117291

2

117887

53

119623

36

8.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January-04-12 11:17:27 AM

Work Order ID: 78269

\*78269\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A Purchased No 230 Each 222.0000 4 4

\*AN3C6A\*

BOLT

\*\*

BL 12-1-20

Location	Loc Qty	Loc Code
FP001	1	
111982	1	
ST351	221	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449 ✓	100	
119749	53	

4.

NAS1149C0832R

Purchased No

230 Each 319.0000 1 1

\*NAS1149C0832R\*

WASHER

\*\*

BL 12-1-20

Location	Loc Qty	Loc Code
ST297	319	
114915 ✓	319	

1

D3536-25

Manufactured No

230 Each 18.0000 1 1

\*D3536-25\*

Gasket

\*\*

BL 12-1-20

Location	Loc Qty	Loc Code
FP002	18	
75039 ✓	18	

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

January-04-12 11:17:27 AM

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

12.0000 1 1

**\*D3794-3\***

Gasket

\*\*

*BL 12-1-20.*

Location

Loc Qty

Loc Code

FP002

12

74530

2

74596 ✓

10

AN3C5A

Purchased No

230 Each

864.0000 34 34

**\*AN3C5A\***

Bolt

\*\*

*BL 12-1-20.*

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

857

116419

28

117343

17

117764

49

117872

2

119127

500

119749 ✓

261

D3537-1

Manufactured No

230 Each

6.0000 3 3

**\*D3537-1\***

Wearpad

\*\*

*BL 12-1-20.*

Location

Loc Qty

Loc Code

FP002

6

69817

5

74867

1

*3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Page 8

Work Order ID: 78269

\*78269\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25 Manufactured No

230 Each 16.0000 1 1

\*D3535-25\*

Wearshoe

\*\*

BL 12-1-20

## Location

## Loc Qty

## Loc Code

FP001

16

62233

1

74592

3

75040 ✓

12

D3492-3 Manufactured No

230 Each 21.0000 8 8

\*D3492-3\*

Plug

\*\*

BL 12-1-20

## Location

## Loc Qty

## Loc Code

FP002

21

74447

9

74871

12

AN960C10L \*NAS1149C0332 ✓ Purchased No

230 Each 0.0000 38 38

\*AN960C10I \*

washer

\*\*

38. BL 12-1-20

D3488-042 Manufactured No

230 Each 13.0000 1 1

\*D3488-042\*

Blade Fitting Assembly, RH

\*\*

BL 12-1-20

## Location

## Loc Qty

## Loc Code

FP002

13

62003

1

69904 ✓

1

71883

1

75068

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

January-04-12 11:17:28 AM

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,094.000

38

38

**\*AI S4-1032-225\***

\*\*

*BL 12-1-20.*

Insert

Location

Loc Qty

Loc Code

ST281

1094

108696

199

110768

62

118386 ✓

765

118966

68

*38*

D3492-1

Manufactured

No

230

Each

110.0000

8

8

**\*D3492-1\***

\*\*

*BL 12-1-20.*

Plug

Location

Loc Qty

Loc Code

FP002

110

69531

8

74444

2

\* 76235 ✓

100

*4*

*4*

D3793-1

Manufactured

No

230

Each

9.0000

1

1

**\*D3793-1\***

\*\*

*BL 12-1-20.*

Wearshoe

Location

Loc Qty

Loc Code

FP001

9

75038 ✓

9

*1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Picklist Print

January-04-12 11:17:28 AM

Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

80.0000

1

1

**\*AN8C35A\***

BOLT

\*\*

*Bl 12-1-20.*

Location

Loc Qty

Loc Code

FP002

79

115960

1

117834 ✓

22

118286

56

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

39.0000

1

1

**\*MS21083C8\***

NUT

\*\*

*Bl 12-1-20.*

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

38

115884

0

118077

1

118614 ✓

6

119309

2

119436

25

119638

4

D2745

Manufactured

No

230

Each

81.0000

8

8

**\*D2745\***

Bushing

\*\*

*Bl 12-1-20.*

Location

Loc Qty

Loc Code

FP001

81

69529

1

76142 ✓

80

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 78269

**\*78269\***

Parent Item: D350-636-012

**\*D350-636-012\***

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Purchased

No

230

Each

51.0000

4

4

**\*AN6C44A\***

BOLT

\*\*

*BL 12-1-20*

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

49

119125 ✓

29

120095

20

*4*

D3532-1

Manufactured

No

250

Each

20.0000

2

2

**\*D3532-1\***

Spacer

\*\*

*[Signature]*

Location

Loc Qty

Loc Code

ST065

20

74880

20

*74880*

MS21083C8

Purchased

No

250

Each

39.0000

2

2

**\*MS21083C8\***

NUT

\*\*

*[Signature] 12/01/23*

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

38

115884

0

118077

1

118614

6

119309

2

119436

25

119638

4

*119436*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 12

January-04-12 11:17:28 AM

Work Order ID: 78269

\*78269\*

Parent Item: D350-636-012

\*D350-636-012\*

Parent Item Name: Skidtube RH

Start Date: 04/01/2012

Required Date: 18/01/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0863J

Purchased

No

250

Each

159.0000

2

2

\*NAS1149D0863.J\*

WASHER

\*\*

Location

Loc Qty

Loc Code

ST298

159

118078

59

119307

100

118078

D3493-1

Manufactured

No

250

Each

15.0000

2

2

\*D3493-1\*

Washer

\*\*

Location

Loc Qty

Loc Code

ST062

15

70697

2

76237

13

76237

AN8C21A

Purchased

No

250

Each

79.0000

2

2

\*AN8C21A\*

BOLT

\*\*

Location

Loc Qty

Loc Code

ST343

79

118758

5

119530

24

120094

50

119530

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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WORK ORDER  
NO. 78269 M.L.J  
12/01/04

RELEASED

F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 1 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

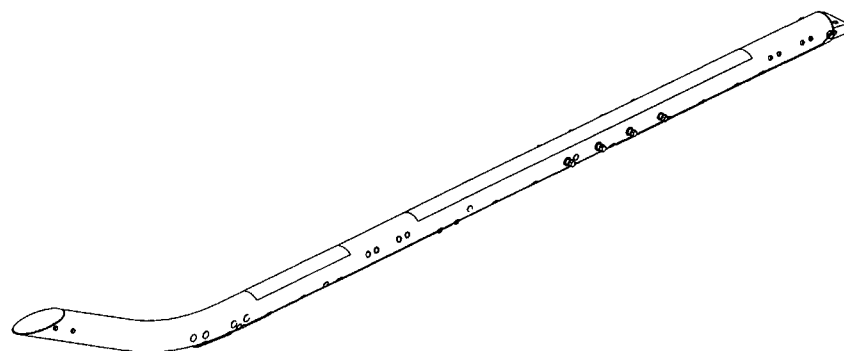
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

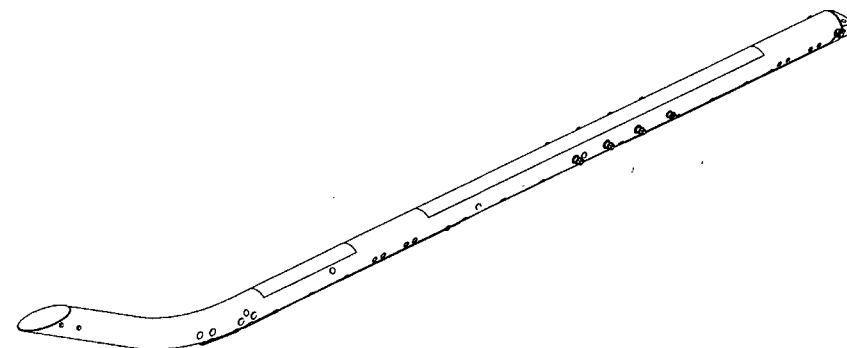
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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88-09-22/11

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
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MFG. APPR.	JA	D2750	SHEET 2 OF 11
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DE APPR.	JA	350 SKIDTUBE ASSEMBLY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

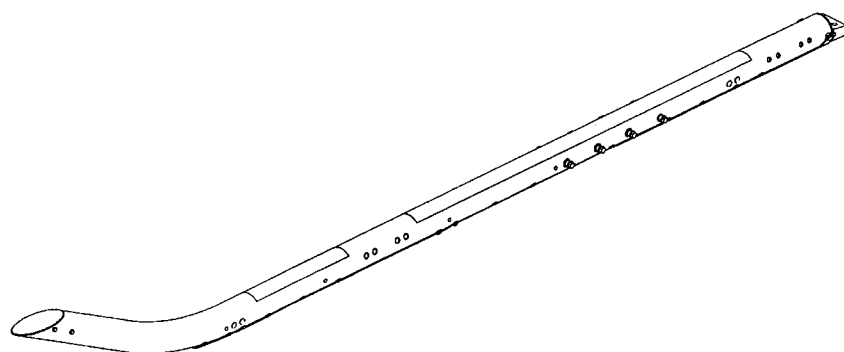
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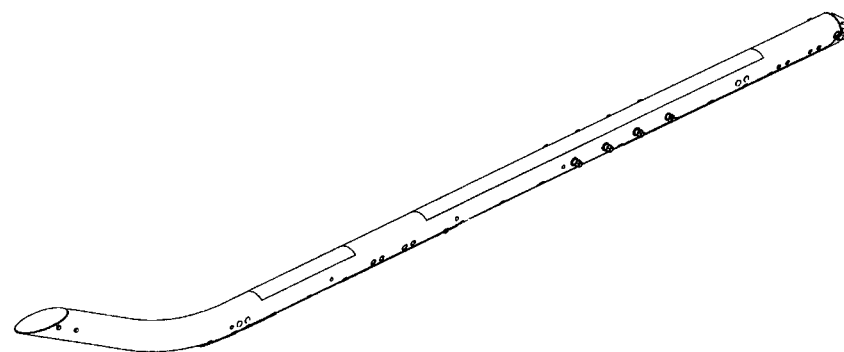
**NOTE:** Date & initial all entries



78269



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
68-9-22/111

DESIGN	<i>PD</i>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	<i>PD</i>		
CHECKED	<i>NA</i>	DRAWING NO. <b>D2750</b>	REV. F SHEET 3 OF 11
MFG. APPR.	<i>NA</i>	TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SCALE NTS
DE APPR.	<i>NA</i>	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DATE	<b>08.07.16</b>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Technical drawing of a shaft assembly with dimensions and callouts:

- Overall Length:** 112.48
- Section A:** Located at the left end, showing a circular feature with a radius of  $R30.0$  and a diameter of  $\phi 0.500^{+0.010}_{-0.000}$  THRU.
- Section B:** Located at the left end, showing a circular feature with a diameter of  $\phi 0.500^{+0.010}_{-0.000}$  THRU.
- Section C:** Located at the left end, showing a circular feature with a diameter of  $\phi 0.500^{+0.010}_{-0.000}$  THRU.
- Section D:** Located at the right end, showing a circular feature with a diameter of  $\phi 0.625^{+0.010}_{-0.000}$  THRU 4 PL.
- Section E:** Located at the left end, showing a circular feature with a diameter of  $\phi 0.500^{+0.010}_{-0.000}$  THRU.
- Section F:** Located at the right end, showing a circular feature with a diameter of  $\phi 0.500^{+0.010}_{-0.000}$  THRU.
- Dimensions:**
  - 112.48 (Overall Length)
  - 49.210 (Distance from Section A to Section C)
  - 22.440 (Distance from Section C to Section D)
  - 56.150 (Distance from Section D to Section F)
  - 12.990 (Distance from Section F to Section E)
  - 20.865 (Distance from Section E to Section C)
  - 12.000 (Distance from Section A to Section B)
  - 5.860 (Distance from Section B to Section C)
  - 8.750 (Distance from Section C to Section D)
  - 14.750 (Distance from Section D to Section F)
  - 2.480 (Distance from Section F to Section E)
- Notes:**
  - DRILL WEARSHOE HOLES USING DRILL TEMPLATE DT8108-1 34 PL
  - 3 EQ. SPACES 4.330 PITCH

Technical drawing of a circular part. The drawing shows a cross-section of a circle with a 23.5 degree angle indicated. A hole is shown with the dimension  $\varnothing 0.500^{+0.010}_{-0.000}$  and the word "THRU" indicating it is a through hole.

Technical drawing of a circular part. The drawing shows a top view of a circular component with a diameter of 0.297. The thickness is indicated as 2 PL. Two angles are shown: 49° REF and 41° REF. The drawing is labeled D4-4.

DESIGN	PA
DRAWN	PE
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MFG. APPR.	
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DE APPR.	
DATE	08.07.16

DRAWING NO. D2750	REV. F SHEET 4 OF 11
TITLE 350 SKIPTUBE ASSEMBLY	SCALE NTS

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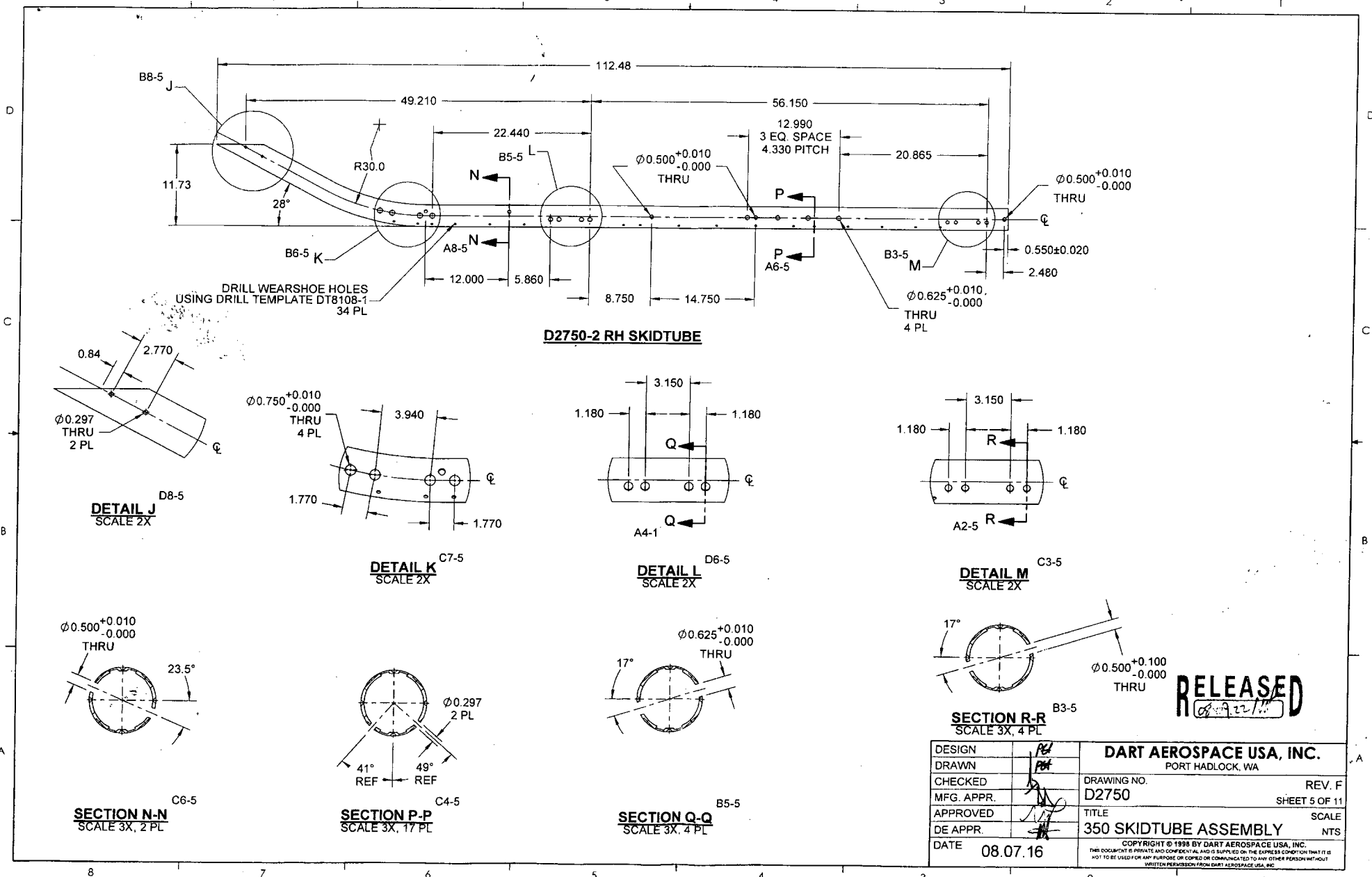
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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APPROVED	PE	350 SKIDTUBE ASSEMBLY	SCALE NTS
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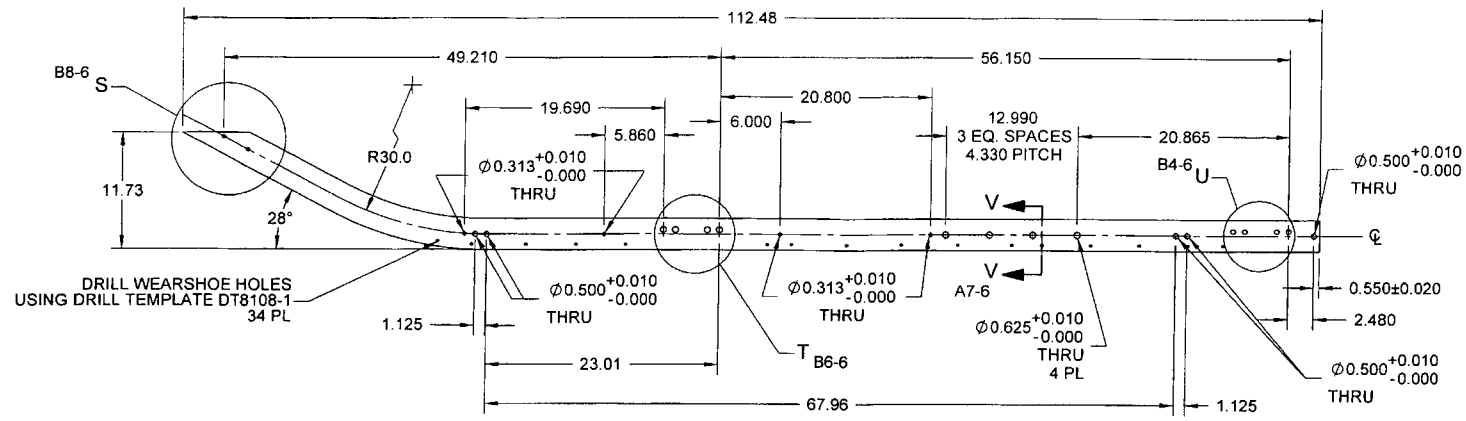
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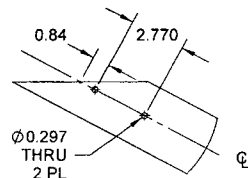
**NOTE:** Date & initial all entries

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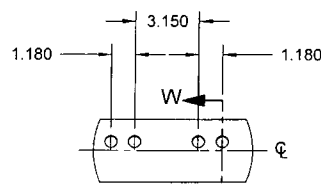
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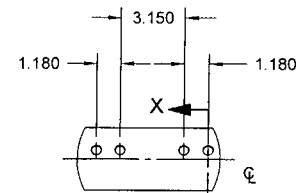
**D2750-3 LH SKIDTUBE**



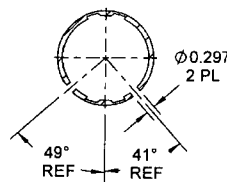
**DETAIL S**  
D8-6  
SCALE 2X



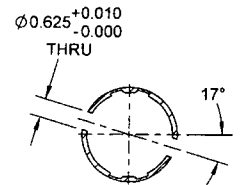
**DETAIL T**  
C5-6  
SCALE 2X



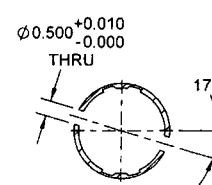
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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CHECKED		DRAWING NO. <b>D2750</b>	REV. F
MFG. APPR.		SHEET 6 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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8 7 6 5 4 3 2 1

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

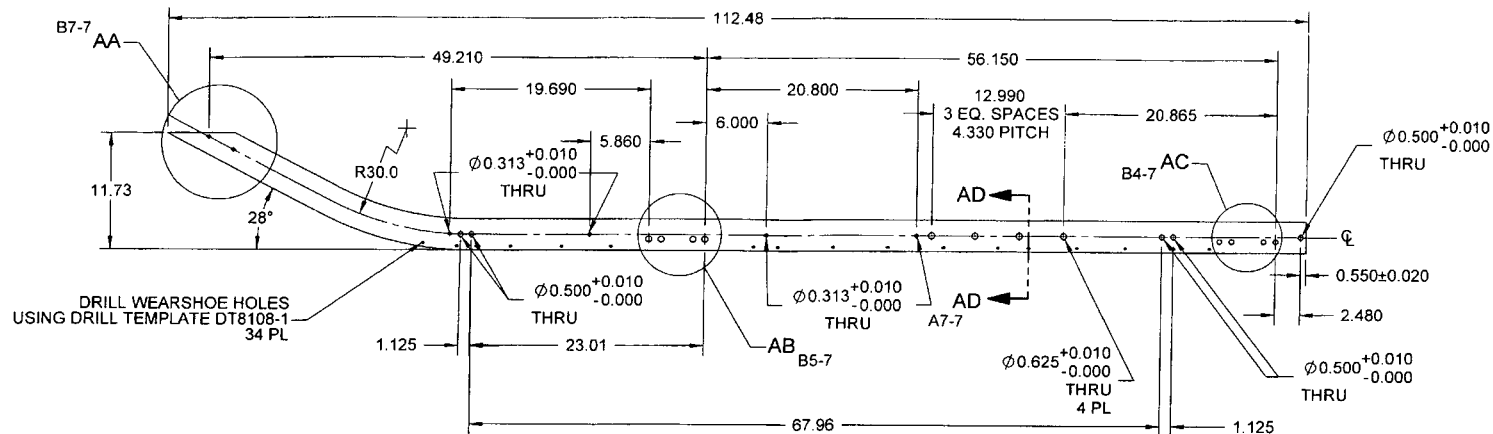
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

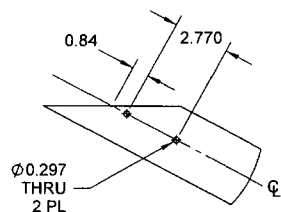
**NOTE:** Date & initial all entries



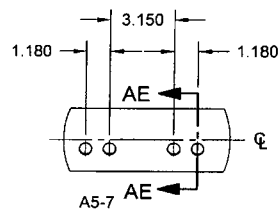
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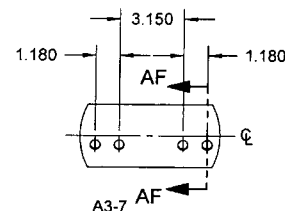
**D2750-4 RH SKIDTUBE**



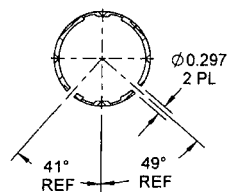
**DETAIL AA**  
SCALE 2X



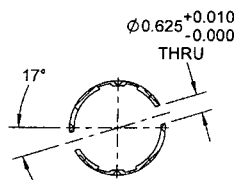
**DETAIL AB**  
SCALE 2X



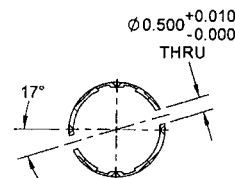
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL



**SECTION AF-AF**  
SCALE 3X, 4 PL

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MFG. APPR.	<i>PH</i>	D2750	SHEET 7 OF 11
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**NOTE:** Date & initial all entries

AN6C44A BOLT  
D2745 BUSHING  
D3631-1 WASHER  
SKIDTUBE, REF  
D3631-1 WASHER  
D2745 BUSHING  
MS21043-6 NUT  
4 PL  
(INSTALL BOLT ON THIS SIDE)

BOND D2739 WEB INTO D2750-1 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015  
NOTE: ENSURE THAT HOLES LINE UP.

2.0 TYP

1.78 TO  
D2739 WEB

D3488-041  
BLADE FITTING

AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-041 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL BOLT ON THIS SIDE)

D3794-1  
GASKET

D3793-1  
WEARSHOE

AN3C5A BOLT  
AN960C10L WASHER  
34 PL

D3537-1  
WEARPAD

D3791-1  
WEARPLATE

D3536-25  
GASKET

D3535-25  
WEARSHOE

D3794-3  
GASKET

D3793-3  
WEARSHOE

D3537-1  
WEARPAD

**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

AFTER FINISH,  
INSTALL  
D3492-043  
PLUG ASSEMBLY  
BOTH ENDS

D3490-3  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D3490-3 SPACER (Ø0.750 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH

**SECTION AH-AH**  
SCALE 3X, 4 PL

C7-8

D2743  
SPACER

TYP

WELDING INSTRUCTIONS  
1) CHAMFER HOLE 0.050 X 45°  
2) INSERT D2743 SPACER (Ø0.625 HOLES)  
3) WELD INTO PLACE, GRIND FLUSH  
4) DRILL OUT SPACER TO Ø0.484

**SECTION AK-AK**  
SCALE 3X, 4 PL

C6-8

D2744  
CAP

1/16" G

AFTER FINISH,  
INSTALL  
ALS4-1032-225 INSERT  
AN3C6A BOLT  
AN960C10L WASHER  
NAS1515H3L WASHER  
4 PL

**DETAIL A8-8**  
SCALE 2X

**RELEASED**

**DESIGN** *PA*  
**DRAWN** *PA*  
**CHECKED** *PA*  
**MFG. APPR.** *PA*  
**APPROVED** *PA*  
**DE APPR.** *PA*  
**DATE** 08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

**DRAWING NO.**  
D2750

**TITLE**  
350 SKIDTUBE ASSEMBLY

**REV. F**  
SHEET 8 OF 11

**SCALE**  
NTS

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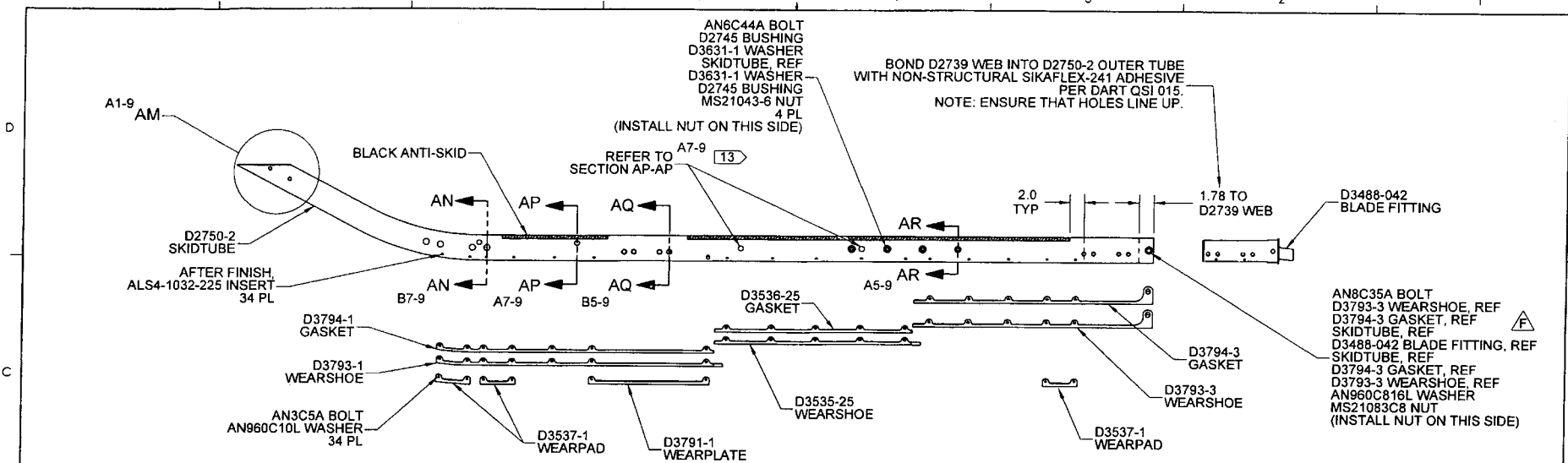
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

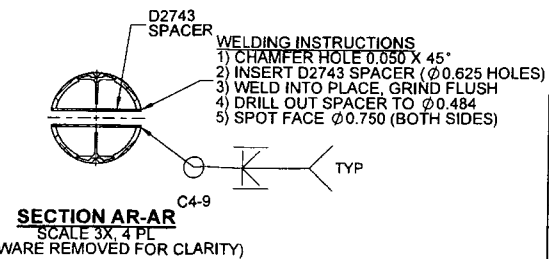
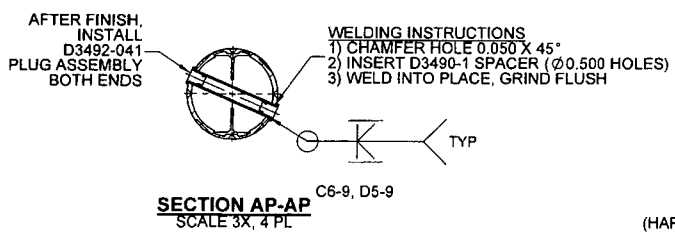
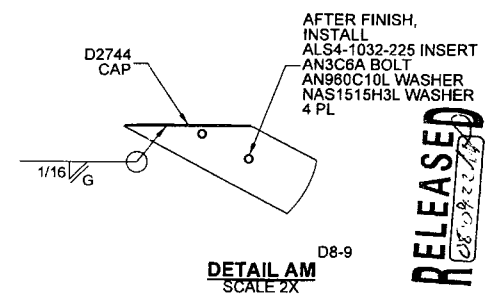
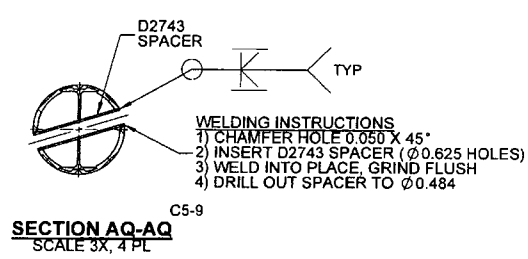
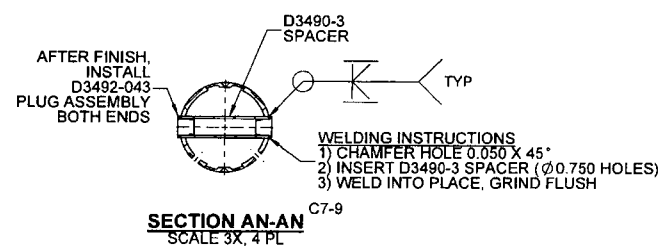
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**NOTE:** Date & initial all entries

78269



**D2750-042 350 SKIDTUBE ASSEMBLY, RH**



DESIGN	PH	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. F
MFG. APPR.	PH	D2750	SHEET 9 OF 11
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DE APPR.	PH	350 SKIDTUBE ASSEMBLY	NTS
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RELEASED  
08-08-2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

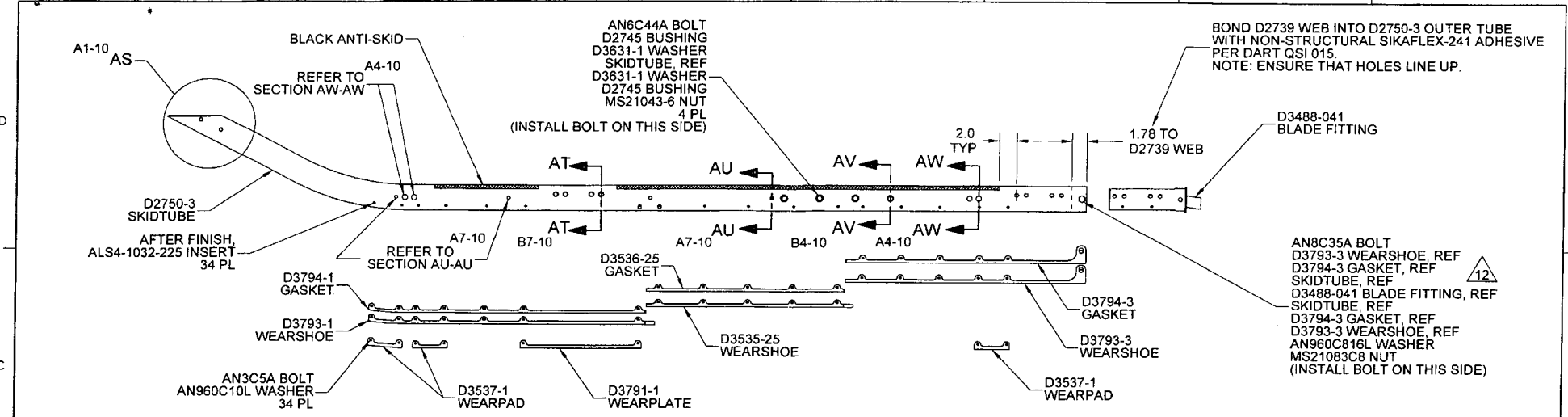
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

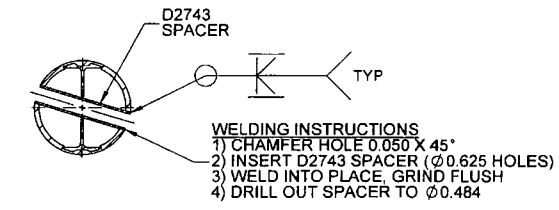
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

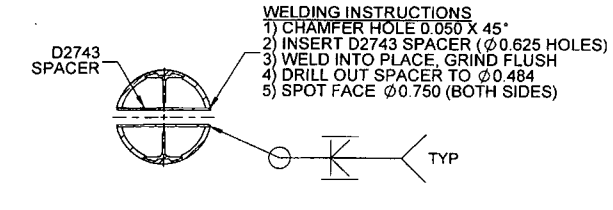
78269



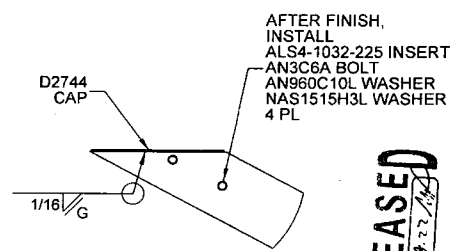
**D2750-043 350 SKIDTUBE ASSEMBLY, LH**



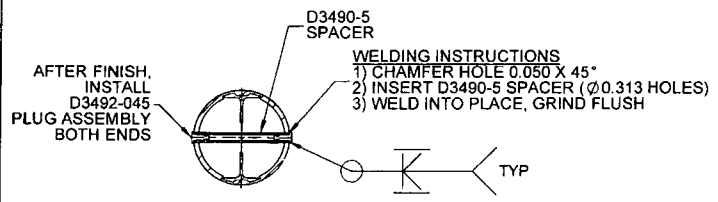
**SECTION AT-AT**  
SCALE 3X, 4 PL



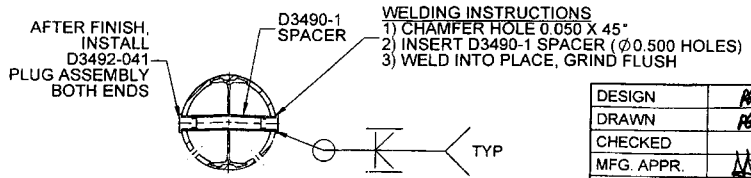
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



**DETAIL AS**  
SCALE 2X



**SECTION AU-AU**  
SCALE 3X, 4 PL



**SECTION AW-AW**  
SCALE 3X, 4 PL

DESIGN	AW	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AW	PORT HADLOCK, WA	
CHECKED	AW	DRAWING NO.	REV. F
MFG. APPR.	AW	D2750	SHEET 10 OF 11
APPROVED	AW	TITLE	SCALE
DE APPR.	AW	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC.	
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RELEASED  
08-27-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

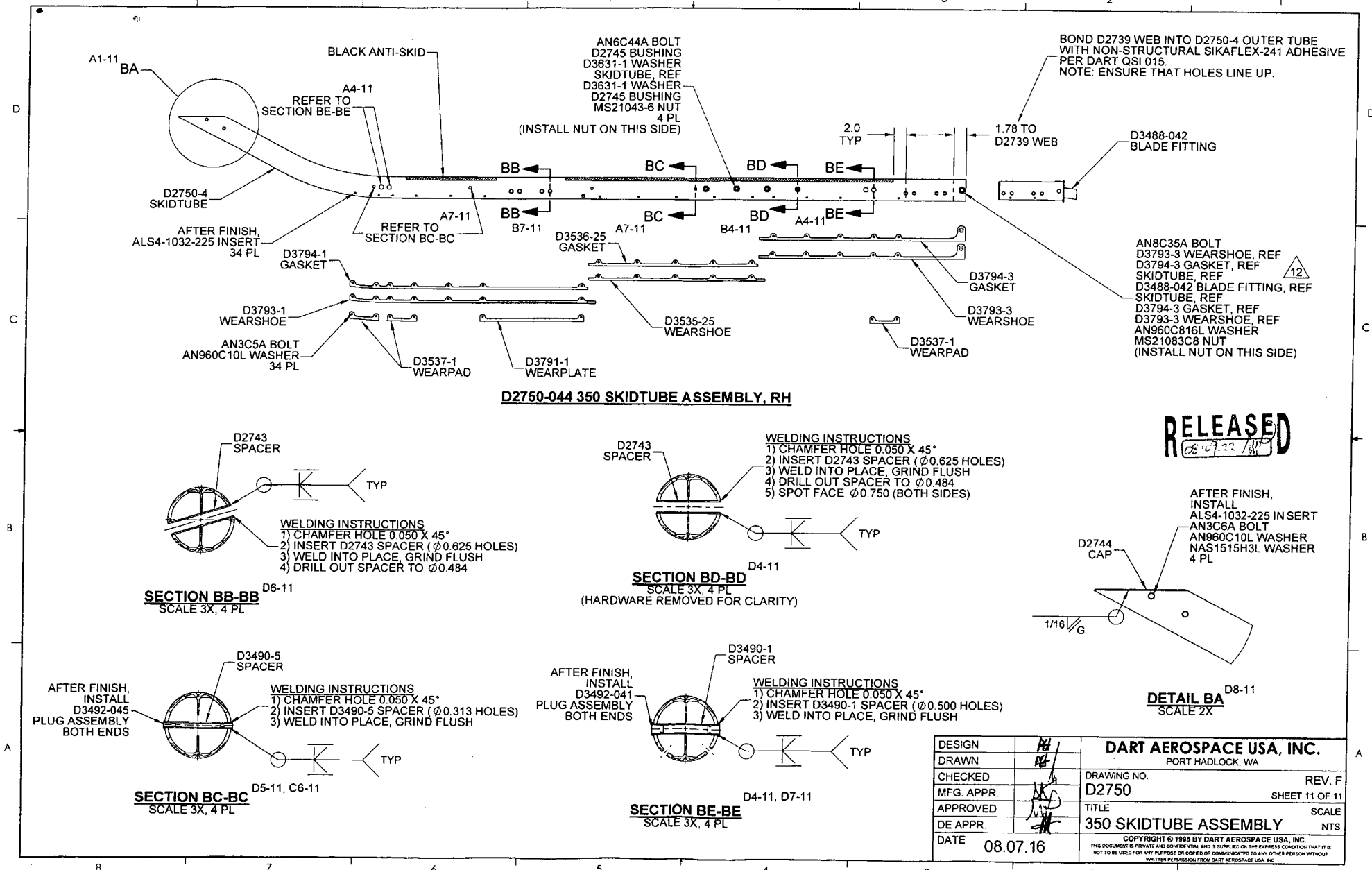
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



78269



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

NO. 279

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 77362  
Part number: D 350 636 012  
Description: 350 skidsteer  
Welding Process: Tig ☒ Mig ☐  
Base material: aluminum  
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐  
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐  
Undercut: pass ☒ fail ☐  
Pin holes: pass ☒ fail ☐  
Overlap (cold lap): pass ☒ fail ☐  
Porosity (surface): pass ☒ fail ☐  
Coloration: pass ☒ fail ☐

Qualifier Pat Lewis Date of Test Coupon 11.12.22

Welder Barclay Elliott Date of Test Coupon 11.12.22

The above named individual is qualified in accordance with AWS D17.1.2001 to weld